

HAI
Work Order ID 54689

December 16, 2009 10:49:52 AM



Page 1

Item ID: D3891-3

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

PJ

Date: *04/12/16*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3891	A

100

0.00



Waterjet

Memo

0.00

B 9-12-16

FLOW CNC Waterjet

1-Cut as per Dwg D3891

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

(D)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B 9-12-16

Quality Control

Work Order ID 54689

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Page 2

Item ID: D3891-3

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 12/16/09

Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09

Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

→ 80916/17

(40)

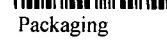
Quality Control

130

Identify as per dwg & Stock Location: QA

0.00

80912/17



Packaging

Memo

0.00

(7)

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

A 10.01.09

Quality Control

B 09/12/18
D

Picklist Print

Page 1

December 16, 2009 10:49:51 AM

Work Order ID: 54689



Parent Item: D3891-3



Parent Item Name: Gasket

Start Date: 12/16/09

Required Date: 12/18/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

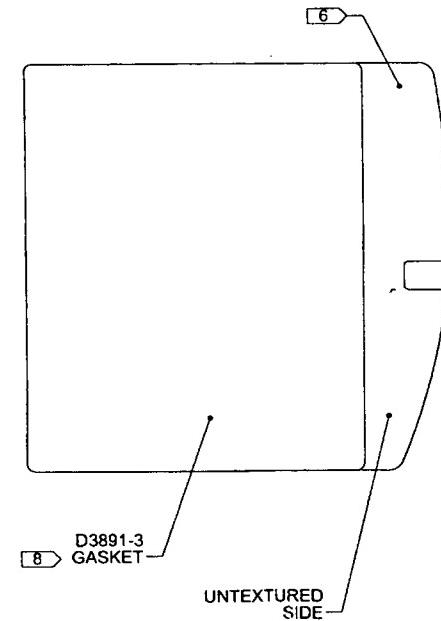
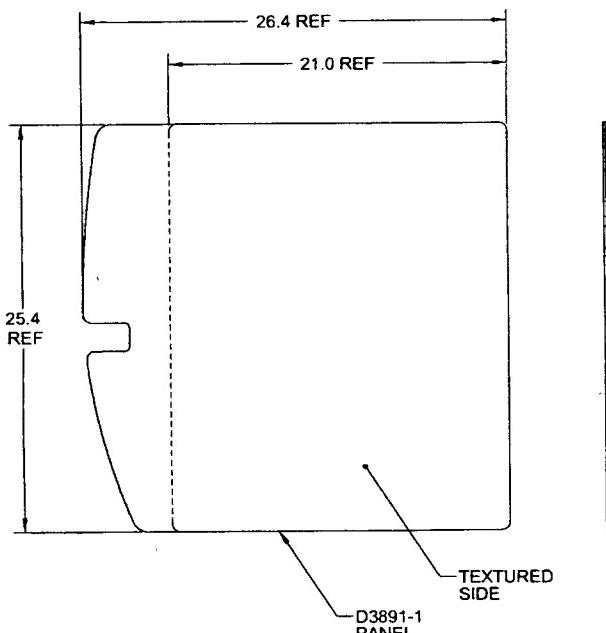
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M4111NS.125		Purchased		No		100	sf	322.3414	3.8989			12/16-12-16

4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

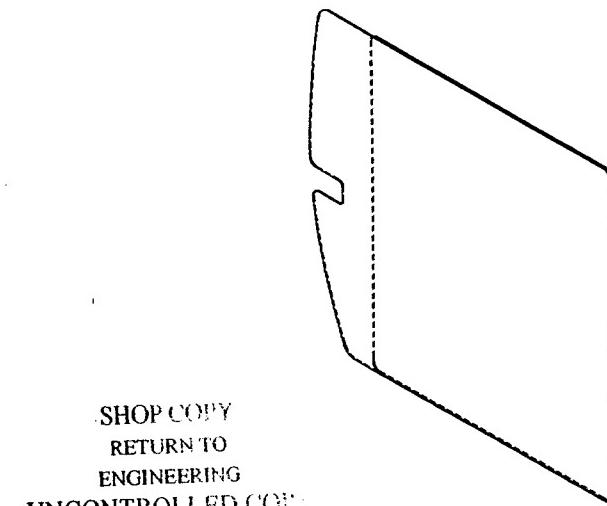
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	322.3414	
112335	322.3414	112335

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3891-041 PANEL, FWD LH****NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 3.67 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54489
Bf 09-12-16

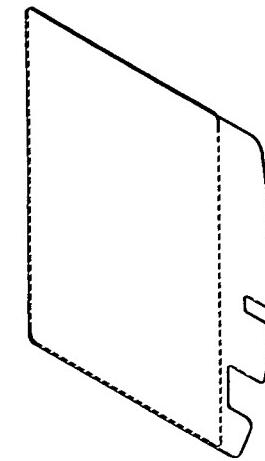
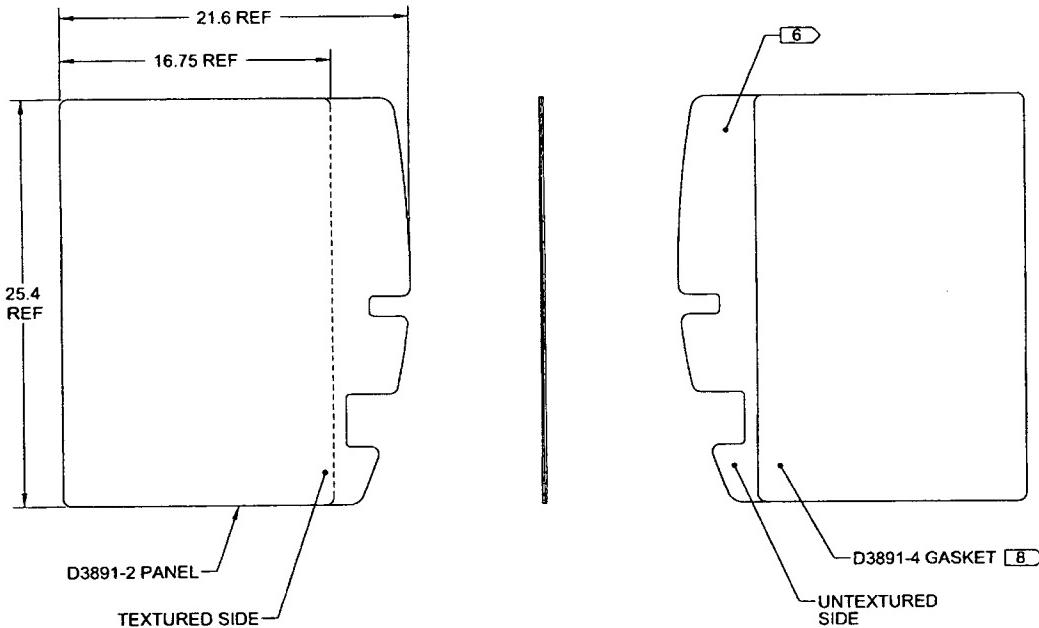
RELEASED
C/06/16 M

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PP</i>	DRAWING NO. D3891 REV. A	
CHECKED	<i>AB</i>	SHEET 1 OF 6	
MFG. APPR.	<i>SP</i>	TITLE PANEL, FWD SCALE NTS	
APPROVED	<i>JW</i>	DATE 09.05.01	
DE APPR.	<i>TH</i>		

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PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE



RELEASED
07/07/01

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

DESIGN	<i>gp</i>	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA	
DRAWN	<i>gp</i>		
CHECKED	<i>pt</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>pt</i>	D3891	SHEET 2 OF 6
APPROVED	<i>am</i>	TITLE	SCALE
DE APPR.	<i>am</i>	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS PROVIDED UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN COMMERCIAL OR INTERNAL BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

w/o 54689

8

7

6

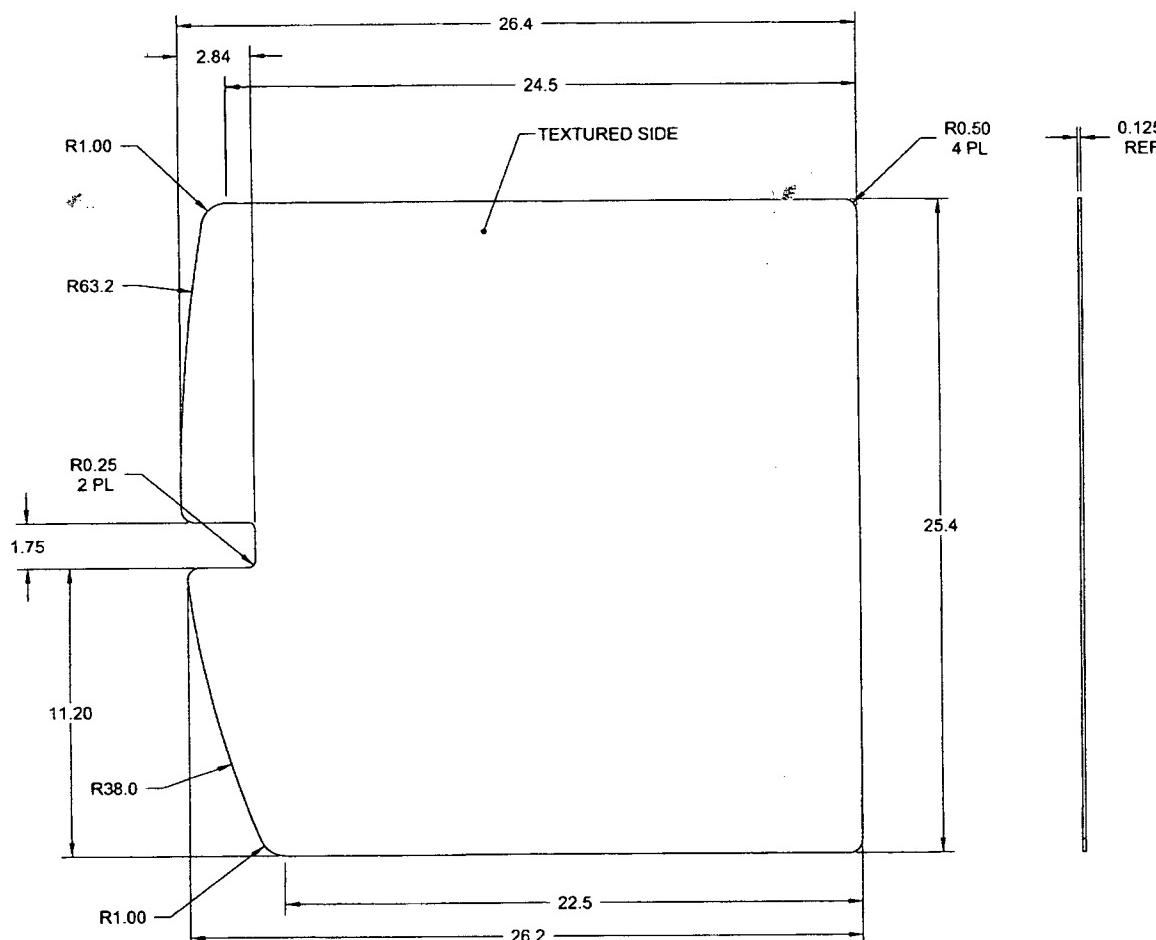
5

4

3

2

1

D3891-1 PANELNOTES:

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.46 lbs

8

7

6

5

4

3

2

1

D

C

B

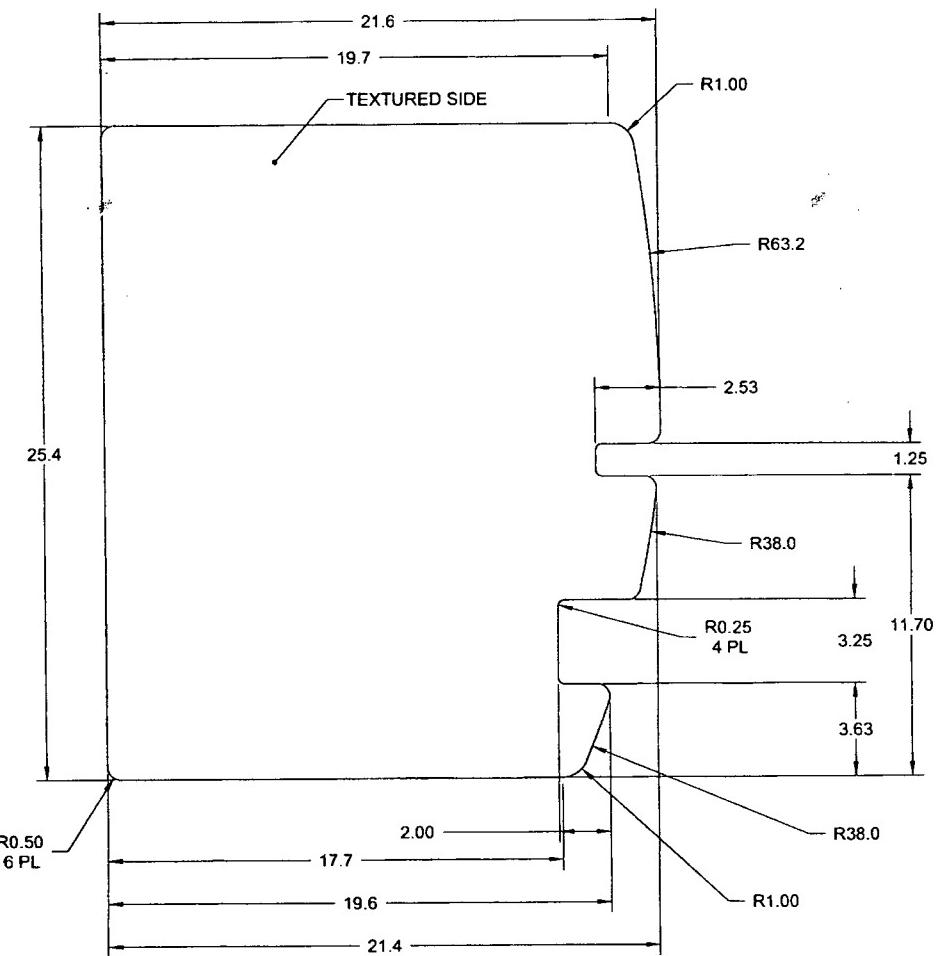
A

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07/16/04

W/0 54689

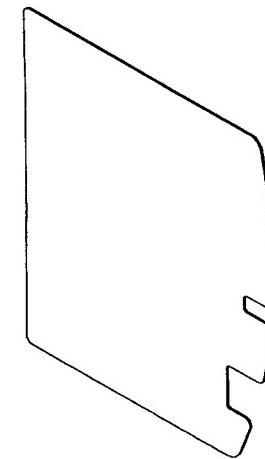
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DRAWN	<i>BP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>BP</i>	D3891	SHEET 3 OF 6
APPROVED	<i>BP</i>	TITLE	SCALE
DE APPR.	<i>BP</i>	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



D3891-2 PANEL

0.125
REF



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09/05/01

w/o 54689

NOTES:

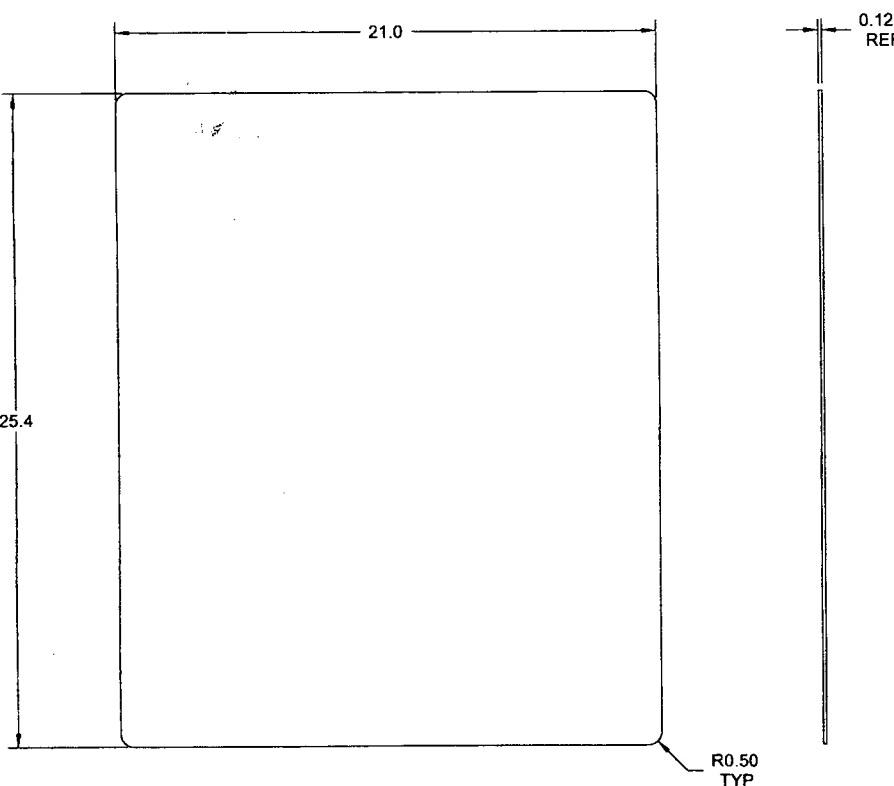
- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.77 lbs

8 7 6 5 4 3 2 1

DESIGN	90	DART AEROSPACE LTD
DRAWN	90	HAWKESBURY, ONTARIO, CANADA
CHECKED	AB	DRAWING NO. REV. A
MFG. APPR.	SJ	D3891 SHEET 4 OF 6
APPROVED	MM	TITLE
DE APPR.	-	SCALE
DATE	09.05.01	PANEL, FWD NTS

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8 1 7 1 6 1 5 1 4 1 3 1 2 1 1



D3891-3 GASKET

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09/06/06

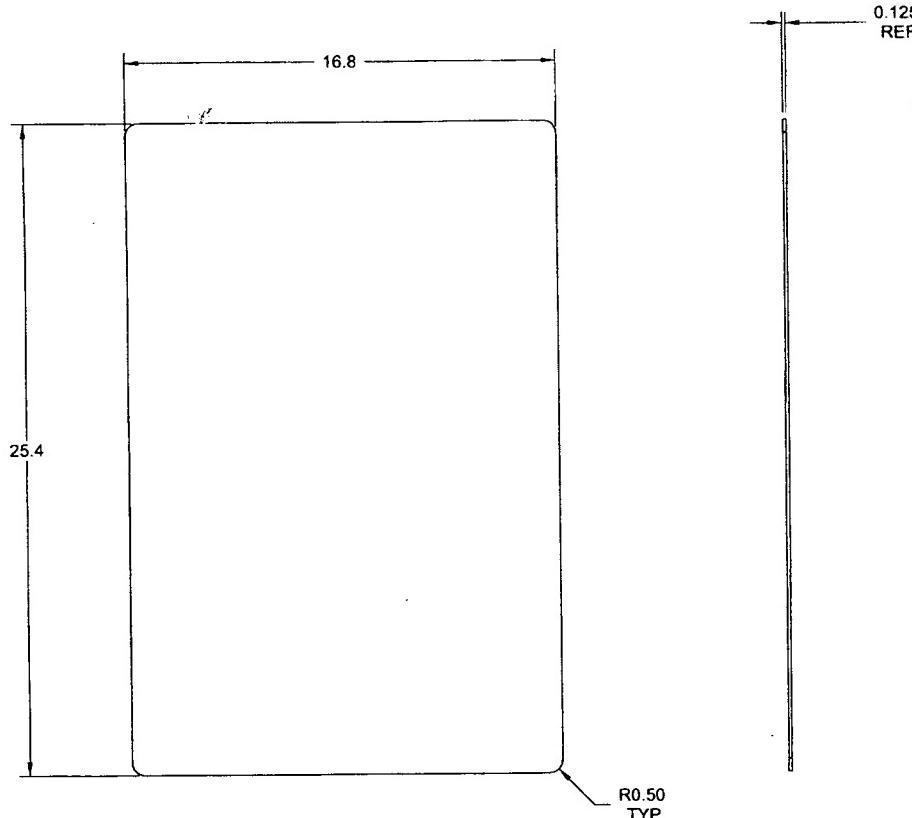
w/o 54679

- NOTES:
1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: NONE
7) WEIGHT: 0.21 lbs

DESIGN	<i>pp</i>	DART AEROSPACE LTD	
DRAWN	<i>pp</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>pp</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>pp</i>	D3891	SHEET 5 OF 6
APPROVED	<i>pp</i>	TITLE	SCALE
DE APPR.	<i>pp</i>	PANEL, FWD	NTS
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8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

8 7 6 5 4 3 2 1



D3891-4 GASKET

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	<i>Q</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PA</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JW</i>	D3891	SHEET 6 OF 6
APPROVED	<i>JW</i>	TITLE	SCALE
DE APPR.	<i>JW</i>	PANEL, FWD	NTS
DATE	09.05.01		

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9/08/16 10:19

w/o 54689

DART AEROSPACE LTD	Work Order:	54689
Description: Gasket	Part Number:	D3891-3
Inspection Dwg: D3891 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	9-12-16	Date:	09/12/17	Date:	N/A
Rev	Date	Change		Revised by	Approved
A	09.07.29	New Issue		KJ	M